

Work Order ID 131441

April-08-15 3:14:47 PM

Ship ASAP April 10
131441

Page 1

Item ID: D066-1001-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: R66 Bearpaws with wearplates - Large

Stop ***NS2***

Start Date: 4/08/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/08/15 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK-ECN15-548

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D066-1001	REV B

ML5

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD066-1001-013

CHG 003

110 Pick Kit 0.00

110

Packaging

Packaging

Memo

PULL FROM STK:

3 X D066-1001-011 B117840

REMOVE FROM EACH KIT:

4 x D3556-1 REV.B

4 X D4953-1 REV.A

GIVE TO SMALL FAB TO SCRAP/DESTROY

ADD TO EACH KIT

4 X D3556-1 REV.C

4 X D4953-1 REV.B

*Cancelled
see 2 faxed
email*

*W
15-04-09*

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Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference: REWORK-ECN15-548

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC4- 100% Inspect kits for completeness	0.00
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120

QC	Memo	0.00
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Quality Control

130	0.00
-----	------

130

Packaging	Memo	0.00
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Packaging	REPACKAGE PER PPP USING NEW B/N NEW PAPERWORK REQUIRED NEW LABELS REQ'D
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Identify and pack for shipping as per PPP D066-1001-013

Location:

PPP Rev:

140	QC21- Final Inspection - Work Order Release	0.00
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140

QC	Memo	0.00
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Quality Control

Picklist Print

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Work Order ID: 131441

131441

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with wearplates - Large

Start Date: 4/08/15

Required Date: 4/08/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D066-1001-013 *D066-1001-013* R66 Bearpaws with wearplates - Large		Manufactured	No				Each	0.0000		1			
									**				
D3556-1 *D3556-1* Clamp For R44 Bearpaw		Manufactured	No				Each	0.0000		4			
									**				
D4953-1 *D4953-1* Cushion		Manufactured	No				Each	0.0000		4			
									**				

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Parent Item Name: Bearpaw Installation, Large

D066-1001-013

Required Date: 5/05/14

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3456-1 *D3456-1* Washer		Manufactured	No				Each	324.0000		20			DAS 26 9-89
									**				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FG			7						
				25701			7						DAS 31 9-89
				ST046			317						
				107629			1						
				111782			100			20x			
				113126			16						
				115051			200						
D3556-1 *D3556-1* Clamp For R44 Bearpaw		Manufactured	No				Each	16.0000		20			DAS 26 9-89
									**				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST457			16						DAS 31 9-89
				112606			16						
D3601-1 *D3601-1* Radius Block		Manufactured	No				Each	124.0000		40			DAS 26 9-89
									**				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST056			124						DAS 31 9-89
				112578			34						
				113846			42			32x			
				115181			48			8x			

Picklist Print

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Work Order ID: 117840

117840

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: Bearpaw Installation, Large

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 5.00

Required Qty: 5.00

D4930-3

Manufactured No

Each 1.0000

D4930-3

Bearpaw

DAS
38\$
9-89
9-89

**

10
118920

DAS
32
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST

1

112356

1

Each

12.0000

* D4952-041

Manufactured No

D4952-041

Wearplate Assembly

DAS
38
9-89

**

40 20

120960 14/8 CV

DAS
26
9-89

Location

Loc Qty

Loc Code

ST550

12

111151

6

111153

6

Each

24.0000

* D4953-1

Manufactured No

D4953-1

Cushion

DAS
38
9-89

**

20

14617

DAS
31
9-89

Location

Loc Qty

Loc Code

ST451

24

110078

4

112255

6

114176

14

118863 x12

DAS
31
9-89

DAS
26
9-89

8x

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Shop Packet Print

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ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date:	15.03.27	Job No.:	ADR Yes/No:	N	ADR Date:		ECN #:	15- 548
Product No.:	D066-1001		Created By:	VS	Approved By:	<i>[Signature]</i>		
Product Name:	Bearpaws		Checked By:	<i>[Signature]</i>				

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	SL/BG	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS/ED	
QC Coordinator	Y	PD	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/HS	
Marketing	N	KO/SL	
Sales Support Manager	N	CP	

Reason for Change:

Cushions spinning under clamps, installation of bearpaw on float skid tubes

Documents Affected:

DSI 9720 Rev. A, D3556 Rev. C, D4953 Rev. B

IF APPLICABLE: NCR: _____ PAR: 14-368 CAR: _____ CIR: _____ URF: _____

PAPERWORK UPDATE ☒ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	MB		
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	Y	VS	URF15-549	15.03.23
6	Update Master Document List (MDL)	Y	VS	MDL-D066-1001 Rev. D	15.03.27
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complets
11	Move / Update Electronic Files / Design Journal	Y	KJ		
12	Update Product Specification Files (Bluefiles)	Y	KJ	Add DSI 9720 Rev. A	
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ		
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ	DSI 9720-011 kit	
18	Create / Update Change Record Form / Item Card Database	Y	KJ	D066-1001-011/-013 now at CHG 003	
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ		
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

- Send copy of DSI 9720 to Florida Suncoast Helicopters
- Update D066-1001-011/-013 kits in stock with new paperwork and new D3556-1 Clamps/D4953-1 Cushions
- Create Routing/BOM for DSI 9720-011 kit
- Scrap D3556-1 Clamps and D4953-1 Cushions in stock

ECN Verified & Complete: _____ Date: _____

Linda Lacelle

From: Victoria Seib
Sent: April-09-15 10:37 AM
To: Linda Lacelle; Jean-Luc Menard
Cc: David Duval; Harvey Siemens
Subject: RE: D3556

Hello,

I have done some investigating and I think there is a problem with the drawing...

Linda,

We are going to have to do some validating and verifying of this drawing. Harvey says you can use the previous revision for the kit you need to ship while we solve this problem.

JL/DD,

I think we are having the same problem with these clamps as with the ones on the D117-840-011 Bearpaw kit where the flat pattern doesn't match the bent part. Are you able to make us a clamp using the DXF you have and verify that it will give us the bent part as it is in the drawing, like we did on the other clamp? I can then update this drawing with the correct dimensions.

Thanks!

Victoria

From: Linda Lacelle
Sent: Thursday, April 09, 2015 7:06 AM
To: Jean-Luc Menard; Victoria Seib
Cc: David Duval
Subject: RE: D3556

We have a kit to ship tomorrow!!

From: Jean-Luc Menard
Sent: April-09-15 8:08 AM
To: Victoria Seib

Cc: Linda Lacelle; David Duval

Subject: D3556

Hi Victoria,

We are running the d3556-1 and the 6.196" dimension is actually 6.225" on the DXF.

Could you let us know Asap if it's the DXF or the dwg that will need revising.

THX

JL

Jean-Luc Ménard

Production Engineering Supervisor

DART AEROSPACE

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